

De rev. 56428

Work Order ID 53476

November 6, 2009 8:40:16 AM



Page 1

Item ID:	D3391-021	Accept		Setup	Start	
Revision ID:	H				Stop	
Item Name:	Fwd Tube Assembly					
Start Date:	05/11/2009	Start Qty:	1.00			
Required Date:	13/11/2009	Req'd Qty:	1.00			
Reference:						

Cust Item ID:
Customer:



Approvals:	Process Plan:		Date:	11-11-5	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3391	Rev H								
100	Skidtubes	0.00							
	Skidtubes								
	Memo	0.00							
	Cut extrusion to 46.52 +0.010 -0.020								
110	BENDING MACHINE - SKIDTUBES	0.00							
	CNC Bend 1								
	Memo	0.00							
	Bend as per Dwg D3391 Using Bend Prog 3391021								
120	QC5- Inspect part completeness to step on W/O	0.00							
	QC								
	Quality Control								

9-11-23

0 11/11/23

2) Sorul 24

Memo
h2 6.700"
L° = B°

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Page 2

Item ID:	D3391-021	Accept		Setup	Start	
Revision ID:	H				Stop	
Item Name:	Fwd Tube Assembly					
Start Date:	05/11/2009	Start Qty:	1.00		Cust Item ID:	
Required Date:	13/11/2009	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	HAAS CNC VERTICAL MACHINING #1	0.00							
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Machine as per Folio FA590 Rev. <u>AA</u> & Dwg D3391 Rev. <u>H</u> Identify as D3391-1 2-Deburr								
140 	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									
150 	CONVENTIONAL MILLING MACHINE	0.00							
Mill Conv	Memo	0.00							
Conventional Milling Machine	Drill X1 Aft cap as per Dwg D3391 .1875" dia								

SP 09/12/08

SP 09/12/08

*mm
09/12/11*

1 8

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Item ID:	D3391-021	Accept		Setup	Start	
Revision ID:	H				Stop	
Item Name:	Fwd Tube Assembly					
Start Date:	05/11/2009	Start Qty:	1.00			
Required Date:	13/11/2009	Req'd Qty:	1.00			
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC Quality Control	Memo	0.00				1	0		
170 	QC8- Inspect parts - second check	0.00							
QC Quality Control	Memo	0.00							

POSITIVE RECALL

EFFECTIVE 09.12.14 AUTH CP

RELEASED CP DATE 10.02.16

★ TEST FTT REQ'D

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3391-021 PAR #: _____ Fault Category: Machined Parts NCR: (Yes) No DQA: _____ Date: 10/03/02
 Resolution: re-work Disposition: re-work QA: N/C Closed: X Date: 10/03/02

NCR: <u>53476</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/12/08	130	Dimension of 3.300 ^{.040} was Too then by .002" at 2.298. and one side at 2.355. R.C. Port was crooked then Install in the Jig.	CP 09.12.14 per 09/10/12	NO Replace TEST FIT PIECE IN MID SECTION → OK 09.02.10	SK 09/12/08	S 10/02/10	CP 09.12.14 per 09/10/12	S 10/12/14
		4.250 dimension is 4.219 on one side	CP 09.12.14				CP 09.12.14	S 10/12/10
09.12.14	130	687 dimension is .751. .054 over tolerance R.C. process (for both issues)	CP 09.12.14 per 09/10/12	BLEND OUT TRANSITION FROM SECOND PASS. The OK. No significant effect on strength.		J 10/02/10	CP 09.12.14 per 09/10/12	S 10/02/10

NOTE: Date & initial all entries

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Item ID: D3391-021

Accept



Setup Start



Revision ID: H

Stop



Item Name: Fwd Tube Assembly

Start Date: 05/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

180



Skidtubes

Skidtubes

0.00

Memo

0.00

1-Drill float bag holes as per Dwg D3391 using DT8798(Do not open tow cap holes to finish size)
(ONLY DRILL HOLES MARKED "A")

2-Drill Remaining two holes for tow cap using DT 8819 Locating off of .1875" holes drilled in previous step

3-Open tow cap holes to .208" as per Dwg D3391

4-Open Tow Ring hole to .640" as per Dwg D3391

5- open float bag holes 0.328" and counter sink as per dwg D3391

6-Deburr & Scribe Batch number Inside aft end.

7-Transfer drill D3391-021 with D3391-023

H 10/21/16

190



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S 10/21/16

8E 10/02/16



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Item ID: D3391-021
Revision ID: H
Item Name: Fwd Tube Assembly
Start Date: 05/11/2009 Start Qty: 1.00
Required Date: 13/11/2009 Req'd Qty: 1.00
Reference:

Accept



Setup Start



Stop



Cust Item ID:
Customer:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200 	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00				1			11/2/17
Hand Finishing									
210 	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									
220 	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1-instal spacers as per dwg D3391 A/R Magnabond 6398 batch: <u>10YSA111130</u> exp. date: <u>10YSA111130</u> cure time 12hrs. as per QSI015 2- grind crossbolt flush 3-back drill crossbolt if necessary								11/2/17 11/2/18

DP

10-2-17

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Item ID:	D3391-021	Accept		Setup	Start	
Revision ID:	H				Stop	
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Start Date:	05/11/2009	Start Qty:	1.00		Cust Item ID:	
Required Date:	13/11/2009	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	⇒ 8 10/02/18			ⓧ			
240 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 8:45 OVEN TEMPERATURE: 320 FINISH TIME: 9:15	0.00 0.00	Bl 10-02-19		ⓧ				
250 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	⇒ m-h 10/02/22		ⓧ				

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Item ID:	D3391-021	Accept		Setup	Start	
Revision ID:	H				Stop	
Item Name:	Fwd Tube Assembly					
Start Date:	05/11/2009	Start Qty:	1.00		Cust Item ID:	
Required Date:	13/11/2009	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
255	Skidtubes	0.00							
	Skidtubes								
	Skidtubes								
	Memo	0.00							
	**** install D3591-1 spacer as per DSI9364 and wearplate and gasket as per DWG ****								
257	QC5- Inspect part completeness to step on W/O	0.00							
	QC								
	Quality Control								
	Memo	0.00							
260	Identify as per dwg & Stock Location:	0.00							
	Packaging								
	Packaging								

7 m-h 10/02/23

S do 12/23

40

used on w/o 53544 m-h 10/02/23



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Item ID: D3391-021 Accept  Setup Start 
Revision ID: H Stop 
Item Name: Fwd Tube Assembly
Start Date: 05/11/2009 Start Qty: 1.00  Cust Item ID:
Required Date: 13/11/2009 Req'd Qty: 1.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

10/02/23 
MF
10-2-23

Picklist Print

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Page 1

Work Order ID: 53476

Parent Item: D3391-021RevH

Parent Item Name: Fwd Tube Assembly


Comments:

Start Date: 05/11/2009

Required Date: 13/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6013-047RevA		Manufactured	No			100	Each	57.0000	1.0000			
												
Skidtube Material												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

57

23935

5

26547

52

255

Each

131.0000

4.0000

Handwritten: 9-11-23
①

D3670-4-200RevA

Manufactured

No



SPACER

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

131

46106

4

48198

42

48269

85

255

Each

22.0000

1.0000

Handwritten: 4 10/2/17

D3401-041RevB

Manufactured

No



Tow Cap Assembly

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

22

36216

1

41931

5

46029

16

Handwritten: m.k
10/02/23

Picklist Print

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Work Order ID: 53476



Parent Item: D3391-021RevH



Parent Item Name: Fwd Tube Assembly

Start Date: 05/11/2009

Required Date: 13/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3564-13RevD Wearshoe		Manufactured	No			255	Each	54.0000	1.0000 			<i>X</i>

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP17

42

51611

32

52059

10

Main Warehouse

ST

12

45409

2

46495

10

IX m-h 10/02/23

D3566-13RevC

Manufactured No



Gasket

255

Each

31.0000

1.0000

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

29

51606

29

Main Warehouse

ST

2

45717

1

50265

1

IX m-h 10/02/23

Picklist Print

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Work Order ID: 53476



Parent Item: D3391-021RevH



Parent Item Name: Fwd Tube Assembly



Start Date: 05/11/2009

Required Date: 13/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C10L  washer		Purchased	No			255	Each	3,956.000	10.0000			

NAS1149C0332R

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE	M113288	
FG	100	
103585	100	
Main Warehouse		
ST	3856	
112116	628	
112612	2228	
112933	1000	

10x m-k 10/02/23

AN3C4A  BOLT	Purchased	No				255	Each	994.0000	10.0000			
--	-----------	----	--	--	--	-----	------	----------	---------	--	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse	M113644	
ST	994	
112314	13	
112720	12	
112724	3	
112794	366	
112829	500	
112991	100	

10x m-k
10/02/23

Picklist Print

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Work Order ID: 53476



Parent Item: D3391-021RevH



Parent Item Name: Fwd Tube Assembly

Start Date: 05/11/2009

Required Date: 13/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3672-1RevB Phenolic Washer		Manufactured	No			255	Each	1,860.000	4.0000			

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1360

39275

19

42329

5

47628 ✓

336

52505

1000

Main Warehouse

ST117

500

51674

500

AELS-1032-130

Purchased

No

255

Each

0.0000

2.0000



INSERT

AELS-1032-225

Purchased

No

255

Each

0.0000

10.0000



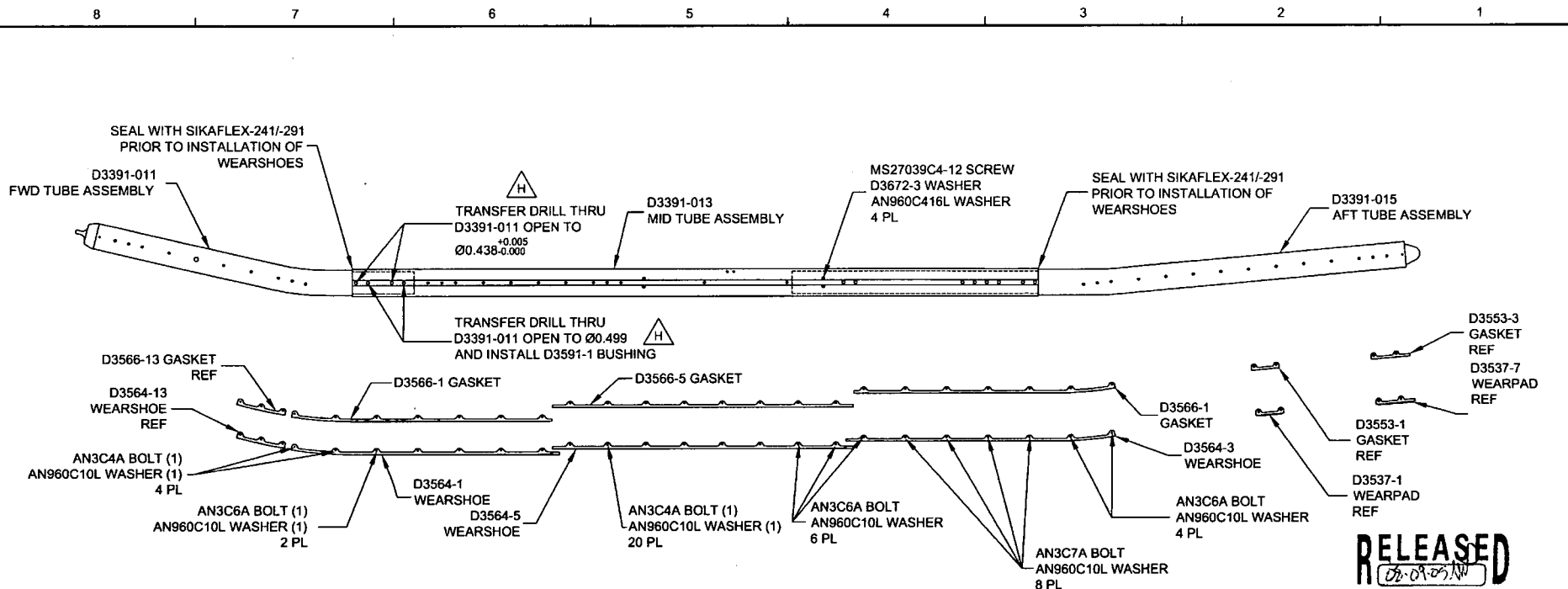
INSERT

10/02/23
4X m-l
M110511 m-l 10/02/22
M110768 m-l 10/02/22

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Shop Packet Print

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


D3391-041 ASSEMBLY

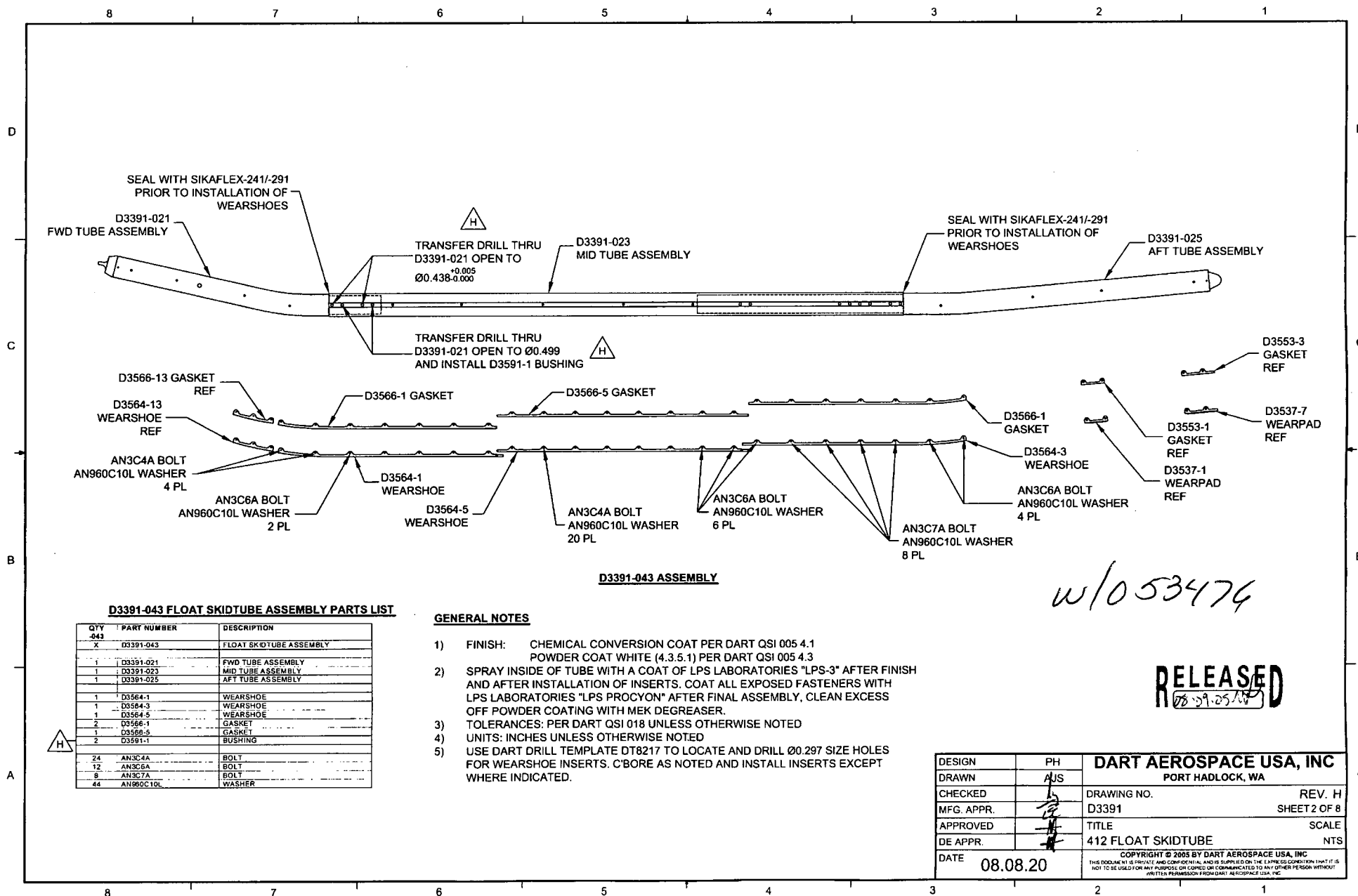
D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

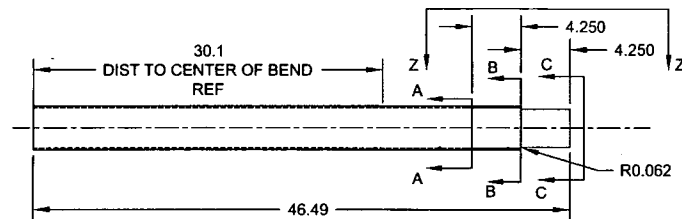
QTY	PART NUMBER	DESCRIPTION
X	D3391-041	Float Skidtube Assembly
1	D3391-011	FWD Tube Assembly
1	D3391-013	MID Tube Assembly
1	D3391-015	AFT Tube Assembly
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
2	D3591-1	BUSHING
4	D3672-3	WASHER
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

GENERAL NOTES

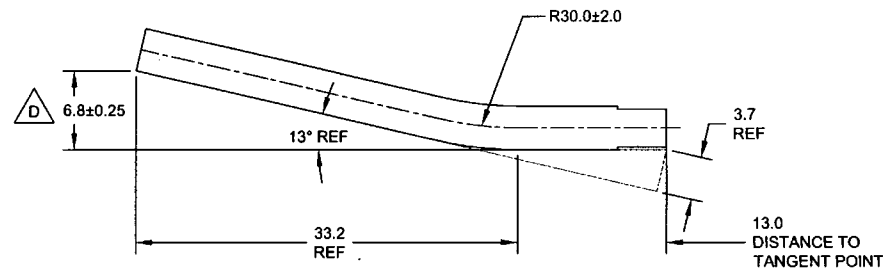
- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 1 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC	
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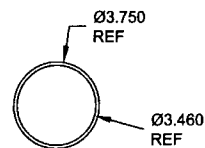




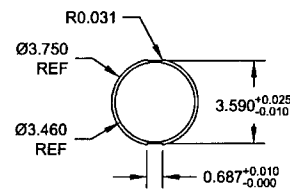
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



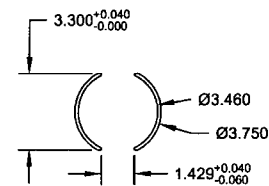
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



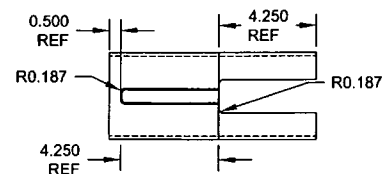
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



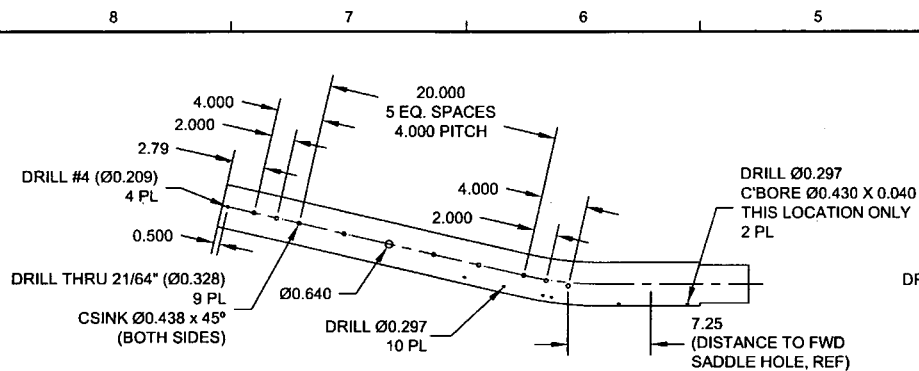
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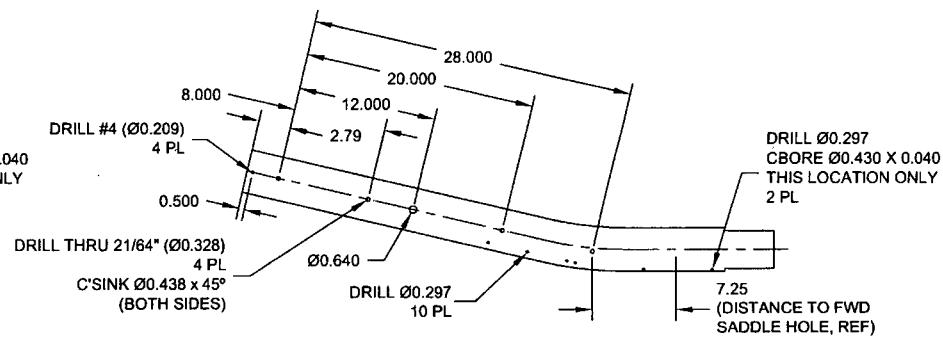
VIEW Z-Z
SCALE 2X

RELEASED
08-05-11

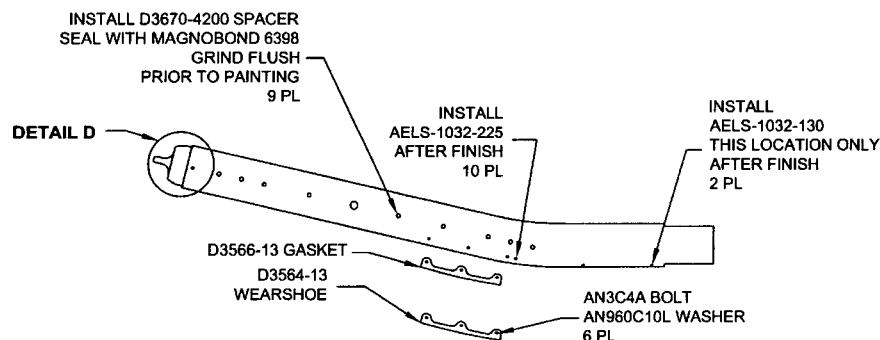
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 3 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	<small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



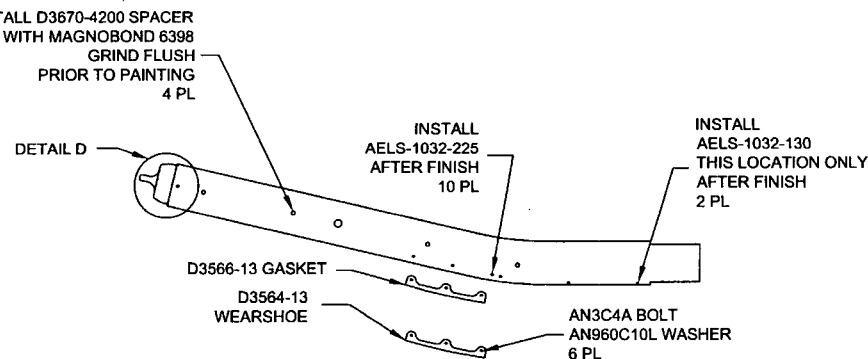
D3391-011 DRILLING DETAIL



D3391-021 DRILLING DETAIL



D3391-011 ASSEMBLY DETAIL

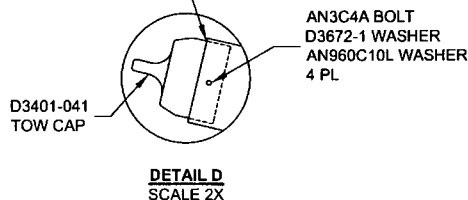


D3391-021 ASSEMBLY DETAIL

D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST

QTY - 011	QTY - 021	PART NUMBER	DESCRIPTION
X	X	D3391-011	FWD TUBE ASSEMBLY
		D3391-021	FWD TUBE ASSEMBLY
1	1	D6013-047	FWD TUBE
1	1	D3401-041	TOW CAP
1	1	D3564-13	WEARSHOE
1	1	D3566-13	GASKET
9	4	D3670-4200	SPACER
4	4	D3672-1	WASHER
10	10	AN3C4A	BOLT
10	10	AN960C10L	WASHER
2	2	AELS-1032-130	INSERT
10	10	AELS-1032-225	INSERT

SEAL WITH
SIKAFLEX-241/-291

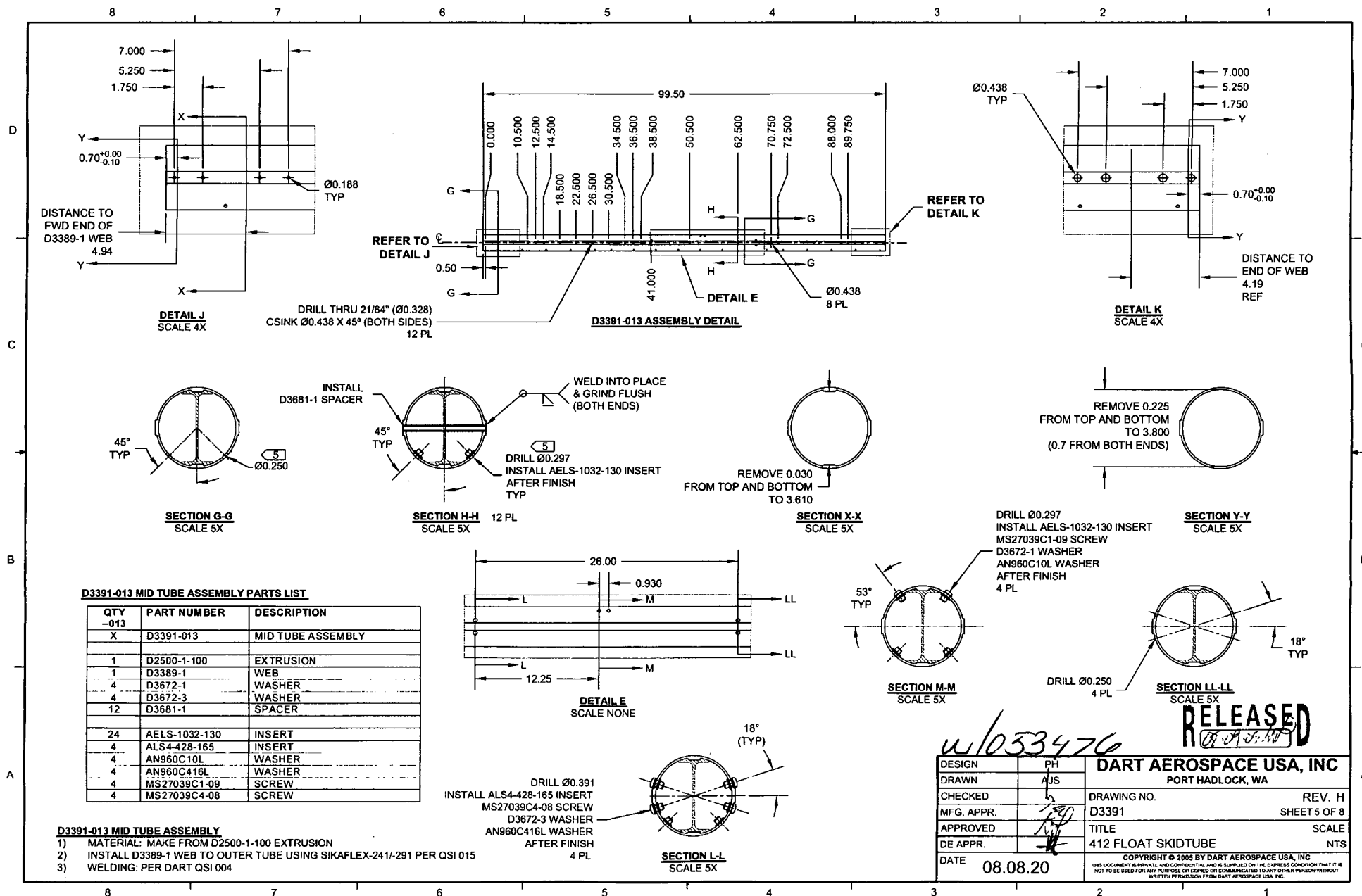


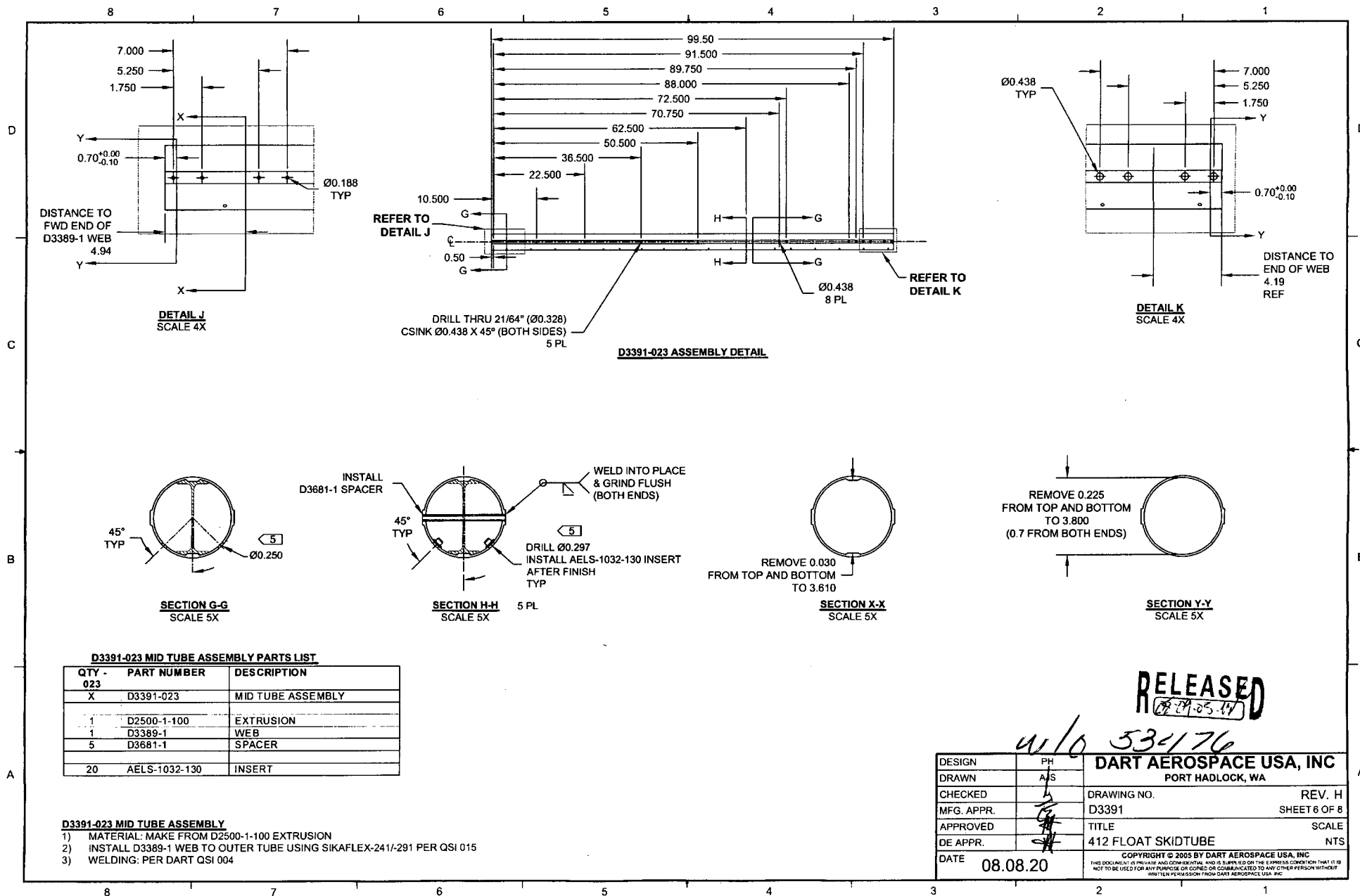
**DETAIL D
SCALE 2X**

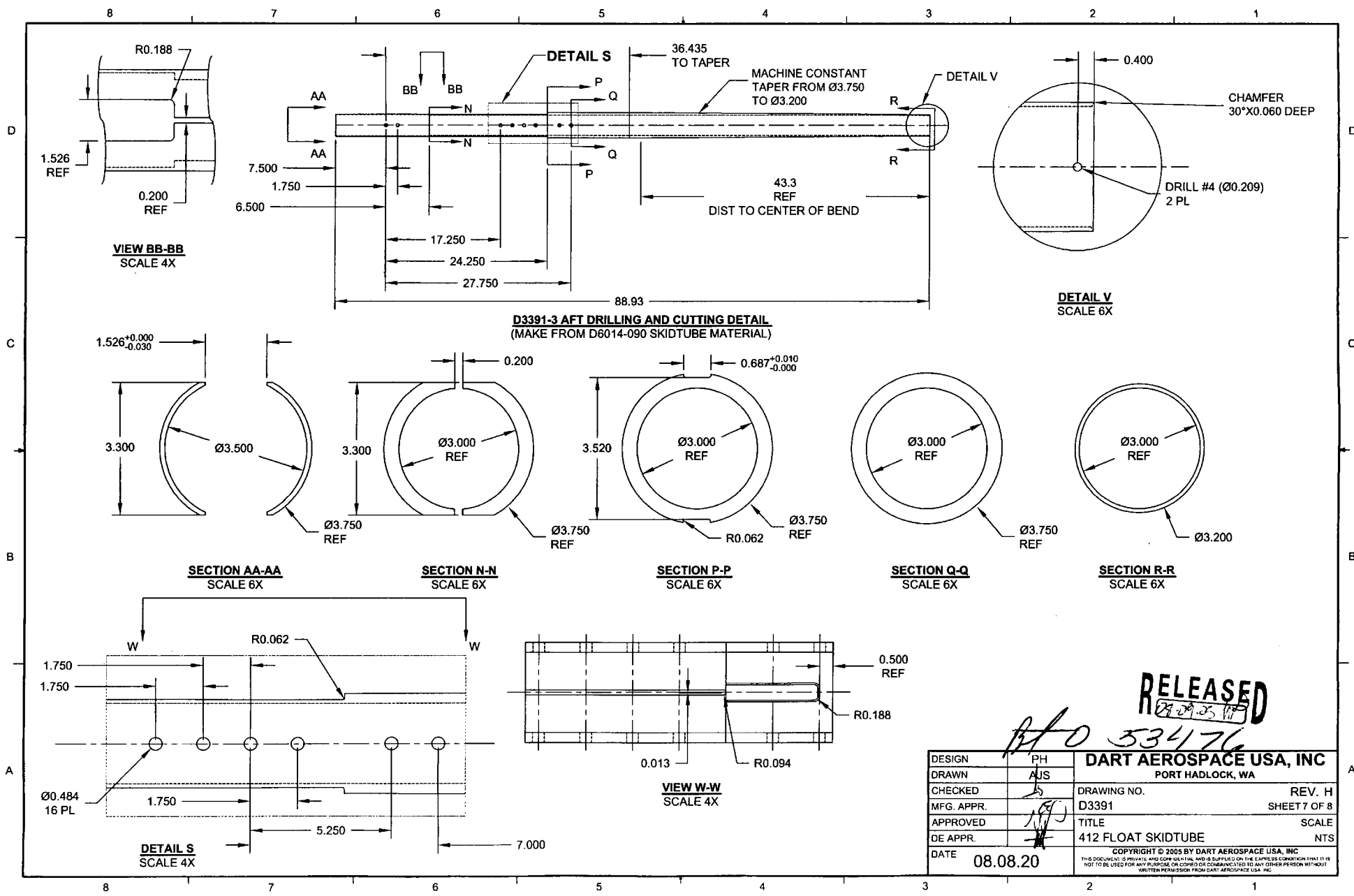
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